

Work Order ID 68723

Wednesday, April 20, 2011 10:22:22 AM



Page 1

Item ID: D4271-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Beam Assembly

Start Date: 4/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *[Signature]*Date: *4/04/20* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4271

B

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Pick and Assemble as per dwg

EP 11/06/20 (2)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Sub 6/20**(+2)*

120

Identify as per dwg & Stock Location: *196*

0.00



Packaging

Memo

0.00

Packaging

11/06/20 [Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Page 2

Accept

**Setup Start**

Abstract

Stop

**Cust Item ID:**

[REDACTED]

Customer:

Reference:

Run Start

[illegible]

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00


00000000000000000000

QC

Memo

0.00

Quality Control

11/6/21 

MF
11-06-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 20, 2011 10:22:29 AM

Page 1
3

Work Order ID: 68723

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly

Start Date: 4/20/2011




Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC
11.01.26 RevB dwg EC verified by:DD

IPP RevB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C13A  BOLT		Purchased	No				Each	35.0000		4		4/21/06/20	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST353			35						
					117366		35						
MS21043-4  Nut		Purchased	No				Each	1,180.000		4		4/21/06/20	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				FG			40						
					104603		40						
				ST300			600						
					117423		600						
				ST301			540						
					114523		3						
					116188		237						
					116549		300						
NAS1149C0432R  Washer		Purchased	No				Each	6,492.000		8		4/21/06/20	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST297			6492						
					116900		1492						
					117291		5000						

M117793 (X)

4

24

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 20, 2011 10:22:29 AM

Page 2

Work Order ID: 68723

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

D4148-3
Stud Receiver, Lower

Manufactured No

100 Each

5.0000

1

Location

Loc Qty

Loc Code

ST132

5

67733

5

D4148-5
Eyebolt Stud

Manufactured No

100 Each

12.0000

1

Location

Loc Qty

Loc Code

ST133

12

67736

12

D4274-3
Plate, Aft Support

Manufactured No

100 Each

6.0000

2

Location

Loc Qty

Loc Code

ST139B

6

68162

6

D4276-1
Aft Beam

Manufactured No

100 Each

3.0000

1

Location

Loc Qty

Loc Code

st200

3

65885

3

Purchased No

100 Each

51.0000

6

Location

Loc Qty

Loc Code

ST351

51

116924

6

117313

45

AN3C12A
Bolts

EPB 11/06/20

2
EPB 11/06/20

2
4
EPB 11/06/20

4
2
EPB 11/06/20

2
12
EPB 11/06/20

M117514 (62)

M117794 (62)

406-A

Wednesday, April 20, 2011 10:22:30 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 20, 2011 10:22:30 AM

Page 3

Work Order ID: 68723

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

✱

MS20615-4M18

Purchased

No

100

Each

346.0000

8



Rivet

Location

Loc Qty

Loc Code

ST323

346

117411

346

MS21043-3

Purchased

No

100

Each

948.0000

6



Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

FP-B

-5

112314

-5

ST301

873

112314

873

NAS1149C0332R

Purchased

No

100

Each

5,261.000

12



Washer

Location

Loc Qty

Loc Code

ST297

5261

116304

55

117291

4606

117460

600

16
EP 4/11/06/20
M114808 (16)

12
EP 4/11/06/20

12
24
EP 4/11/06/20

24

Wednesday, April 20, 2011 10:22:30 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

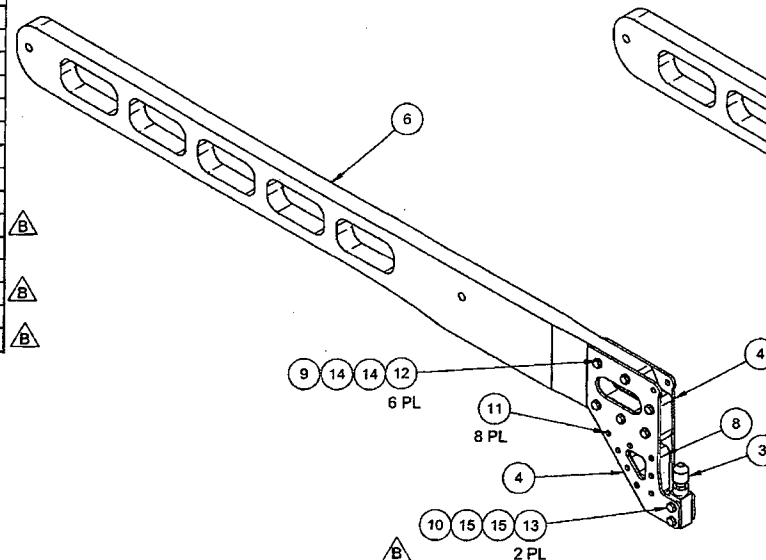
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

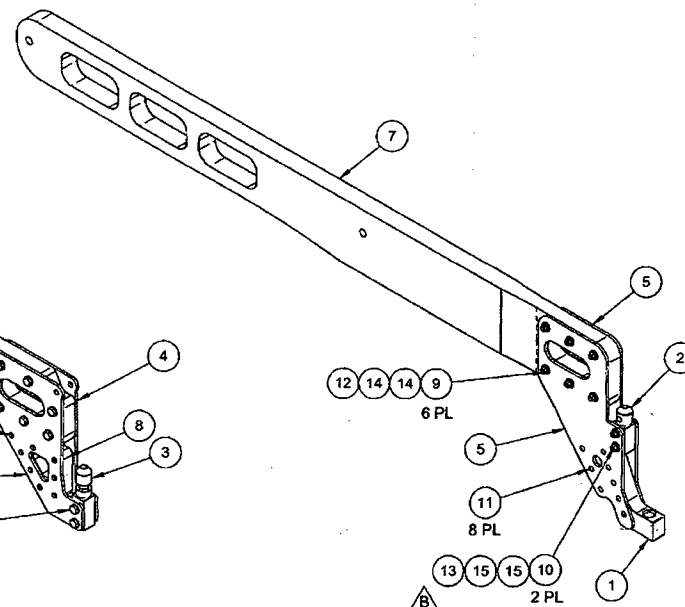
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -011	QTY -013	PART NUMBER	DESCRIPTION
			D4271-011	FWD BEAM ASSY
			D4271-013	AFT BEAM ASSY
1		1	D4148-3	STUD RECEIVER
2		1	D4148-5	EYEBOLT STUD
3	1		D4149-5	EYEBOLT STUD
4	2		D4274-1	PLATE, FWD SUPPORT
5		2	D4274-3	PLATE, AFT SUPPORT
6	1		D4275-1	FWD BEAM
7		1	D4276-1	AFT BEAM
8	1		D4281-1	SPACER
9	6	6	AN3C12A	BOLT
10	2	2	AN4C13A	BOLT
11	8	8	MS20615-4M18	RIVET
12	6	6	MS21043-3	NUT
13	2	2	MS21043-4	NUT
14	12	12	NAS1149C0332R	WASHER
15	4	4	NAS1149C0432R	WASHER



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. *48723*

11-04-20

RELEASED
R 2010-12-06
JWP

B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	SC		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.12.01		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4271 TITLE SUPPORT BEAM ASSEMBLIES SCALE NTS SHEET 1 OF 2 COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

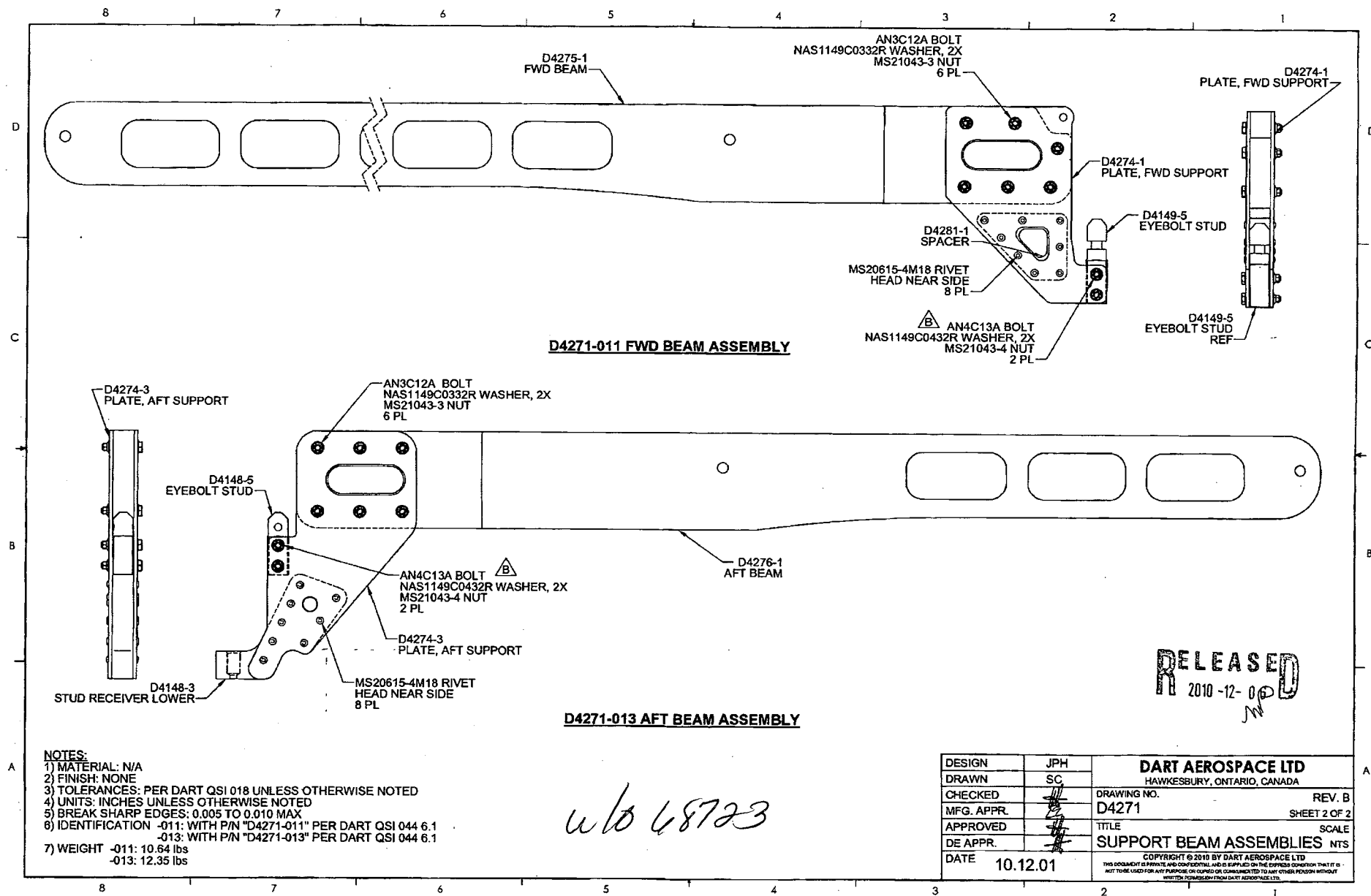
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries